

Work Order ID 66162

Monday, February 07, 2011 11:26:59 AM



Page 1

Item ID: D3953-9

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Washer

Stop



Start Date: 2/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: CMF

Date: 11-02-07 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA855 & DWG

FOLIO REV: C

DWG REV: C

DEBURR

SA 11/2/24

27

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 11/2/24

27

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Process Plan: _____

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Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

*rel 11.2 - 24**24*

Memo

0.00

130



Packaging

Packaging

Identify as per dwg & Stock Location: *089*

0.00

Memo

0.00

Rel 11/25 (24)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/01/25**CH11/02/25*

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Picklist Print

Monday, February 07, 2011 11:26:53 AM

Page 1

Work Order ID: 66162



Parent Item: D3953-9



Parent Item Name: Gas Spring Washer

Start Date: 2/8/2011


Required Date: 2/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC
as per dwg revC DD 10.03.02 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750 		Purchased	No			100	f	84.7470	0.05	1.052632		11/2/24	
Delrin Round Bar 0.75"													

Location

Loc Qty

Loc Code

MAT

34.3

116183

34.3

MAT050

50.447

112418

0.12

← 115472

50.327

-5 RT

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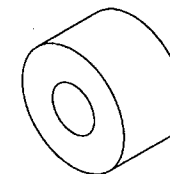
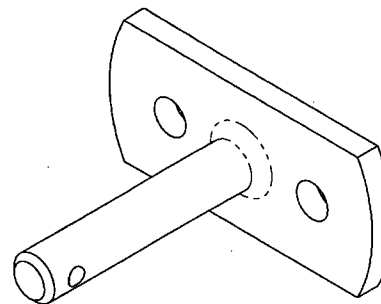
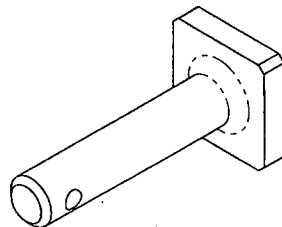
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8 7 6 5 4 3 2 1



766162

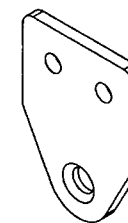
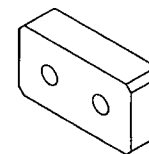
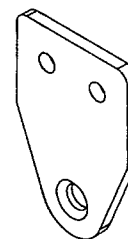
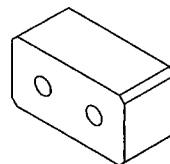
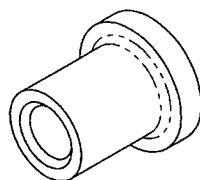
D3953-1 GAS SPRING BRACKET
(FULL LID)

D3953-3 GAS SPRING STUD, LID

D3953-5 GAS SPRING STUD, BASE

D3953-7 GAS SPRING SPACER

D3953-9 GAS SPRING WASHER



RELEASED
2010-02-26

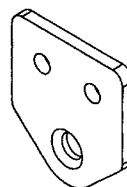
D3953-11 GAS SPRING SPACER

D3953-13 GAS SPRING SPACER
(FULL LID)

D3953-15 GAS SPRING BRACKET
(SPLIT LID)

D3953-17 GAS SPRING SPACER
(SPLIT LID)

D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)

C	PARTS -19 & -21 ADDED (SHT 1& 4); CSK CALLOUT WAS CHAM (C5-2, B6-3, C8-4); & SYMM WAS & SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED, REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3953	SHEET 1 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	GAS SPRING LID COMPONENTS	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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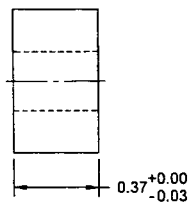
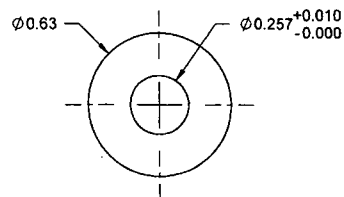
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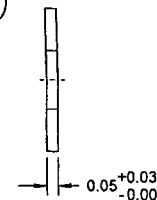
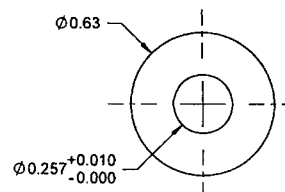
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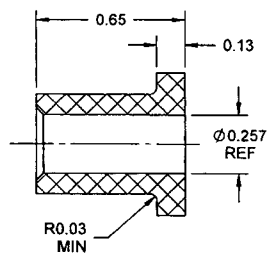
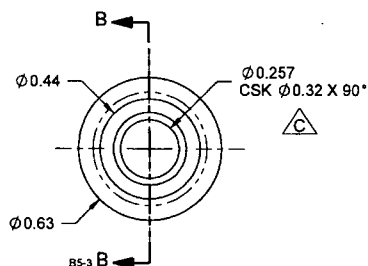
NOTE: Date & initial all entries



D3953-7 GAS SPRING SPACER

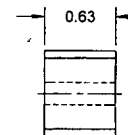
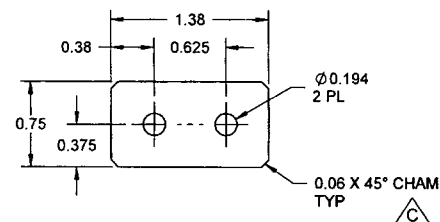


D3953-9 GAS SPRING WASHER



SECTION B-B 87-3

D3953-11 GAS SPRING SPACER



D3953-13 GAS SPRING SPACER

NOTES:

1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS NTS	
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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